



W/O: 97775		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
13/02/22	105	DO NOT DRY MAT.	DL	13/02/22	2.	13/2/22	

Part No: D4758-3 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 97775

**\*97775\***

Page 2

February-22-13 11:13:33 AM

Item ID: D4758-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Blanking Plate  
 Start Date: 2/22/13 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 2/22/13 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
<b>*110*</b>						x2			OK
Thermoform	Memo	0.00							13/02/22
Thermoforming Machine	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA152 using tool DT9873  Dwg Rev: <u>A</u> Folio Rev: <u>A</u>  Visually inspect for proper formation and texture								
140		0.00							
<b>*140*</b>						x2			OK
HandThermo	Memo	0.00							13/02/22
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								



**Work Order ID 97775****\*97775\***

Page 4

February-22-13 11:13:33 AM

Item ID: D4758-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Blanking Plate

Start Date: 2/22/13 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 2/22/13 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

U130222

# Picklist Print

February-22-13 11:13:32 AM

Page 1

Work Order ID: 97775

Parent Item: D4758-3

Parent Item Name: Blanking Plate

Start Date: 2/22/13

Required Date: 2/22/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 13/01/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	629.5360	1	2			

Location

therm

110877

122033

Loc Qty

629.5360009

31.0000009

598.536

Loc Code

2 sq ft

13/02/22

DART AEROSPACE LTD	Work Order: <del>97025</del>
Description: <u>Blanking Plate</u>	Part Number: <u>04758-3</u>
Inspection Dwg: <u>04758</u> Rev: <u>A</u>	Page 1 of 1

**FIRST ARTICLE INSPECTION CHECKLIST**  
**THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DR. Date: 13/02/22

**TRIMMING SECTION**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<u>2.75"</u>	<u>± 0.030</u>	<u>2.74"</u>	✓			
<u>3.01.09</u>	<u>REF</u>	<u>3.01"</u>	✓			

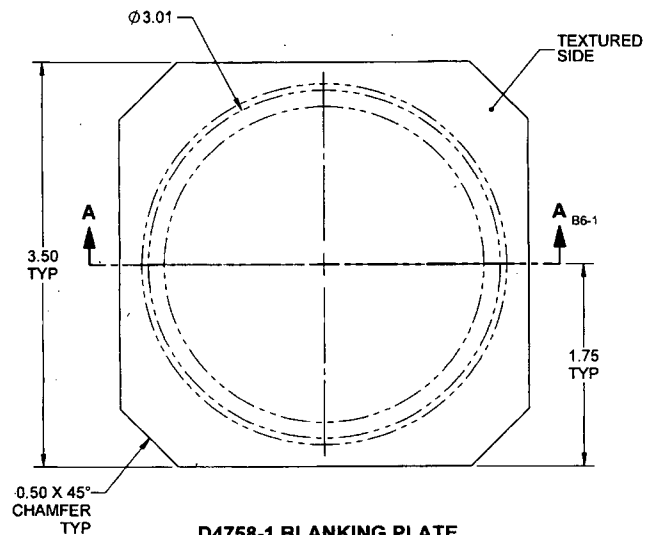
Measured by: DR. Date: 13/02/22

Audited by: JB Date: 13/02/22

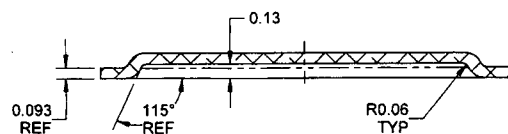
Preliminary Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

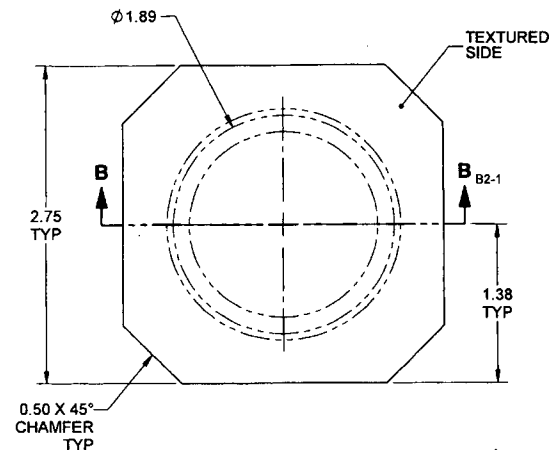
*10-04-14*



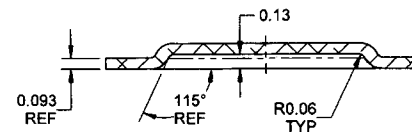
**D4758-1 BLANKING PLATE**



**SECTION A-A C6-1**



**D4758-3 BLANKING PLATE**



**SECTION B-B B2-1**

**NOTES:**

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET, 0.093 THICK  
REF. DART SPEC. MLEXS.093-F6006-02
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4758-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 (PERMANENT PAINT MARKER)
- 7) WEIGHT: D4758-1 = 0.05 lbs; D4758-3 = 0.02 lbs
- 8) TOOLING: - D4758-1: THERMOFORM PER MOLD DT9872 PER QSI 022  
- D4758-3: THERMOFORM PER MOLD DT9873 PER QSI 022

REV.	NEW ISSUE	DESCRIPTION	MB	12.12.07
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	12.12.07			

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4758** REV. A  
SHEET 1 OF 1

TITLE **BLANKING PLATES** SCALE NTS

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**RELEASED**  
2013-01-14

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